

SHIP Wed 22/11

Dart Aerospace Ltd.

Date: Monday, 11/20/2006 11:33:14 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP WELDMENT		
Job Number	: 29537					
Estimate Number	: 10176					
P.O. Number	: N/A			Part Number	: D2563	
This Issue	: 11/20/2006 S.O. No. : N/A			Drawing Number	: D2563 REV C	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: C	
Previous Run	: 28788			Material	: N/A	
Written By	: <i>[Signature]</i>			Due Date	: 11/27/2006	
Checked & Approved By	: <i>[Signature]</i> 06/11/20			Qty:	2	
Comment	: Est Rev: 02.07.31 Re-format Location RF			Um:	Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2244116	Step Extrusion	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		1 D2244 Step Extrusion	
		Batch: <u>B23404</u>	<i>PD 06-11-20 (2)</i>
2.0	D267334	End Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
		Qty Part No. Description	Batch
		2 D2673-34 End Cap	<u>B2539b</u>
			<i>PD 06-11-20 (2)</i>
3.0	D2561	Lug Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
		Qty Part No. Description	Batch
		2 D2561 Lug Plate	<u>B244b1</u>
			<i>PD 06-11-20 (2)</i>
4.0	D2564	Mounting Angle	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
		Qty Part No. Description	Batch
		2 D2564 Mounting Angle	<u>B2741b</u>
			<i>PD 06-11-20 (2)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 29537		Part Number: D2563
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	LARGE FAB 1 	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1		
1-Cut D2244 to 89.70" at 34° as per Dwg D2563		
2-Deburr ends		
3-Weld (1 End CAP,LUG PLATES & MOUNTING ANGLE as per Dwg D2563 using DT 8343 A/R AL ROD Batch: <u>H101446</u>		
4-Grind		PD 06-11-20 (2)
6.0	QC5/9 	WELD INSPECTION 
Comment: WELD INSPECTION <u>1106/11/21 (2)</u>		
7.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		
8.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION <u>11.06.21 (2)</u>		
9.0	LARGE FAB 1 	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1		
1-Inspect for foreign object per QSI 024 <u>11.06.21 (2)</u>		
2-Weld Remaining End as per Dwg D2563 using DT 8343 A/R AL ROD Batch: <u>1106/11/21 (2)</u>		
3-Grind <u>11.06.21 (2)</u>		
10.0	QC9 	VISUAL WELDING INSPECTION 
Comment: VISUAL WELDING INSPECTION <u>1106/11/21 (2)</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/11/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D2563

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/06/11/21 (2)

12.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Touch up Alodine then a.m 06/11/21

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 a.m 06/11/22 (2)

13.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2563 and QSI 005 4.4 M 102635

a.m 06/11/22 (2)

14.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06/11/22 (3)

15.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/22 (2)

Job Completion

W
146



Package per PPP D205633

U 06/11/22

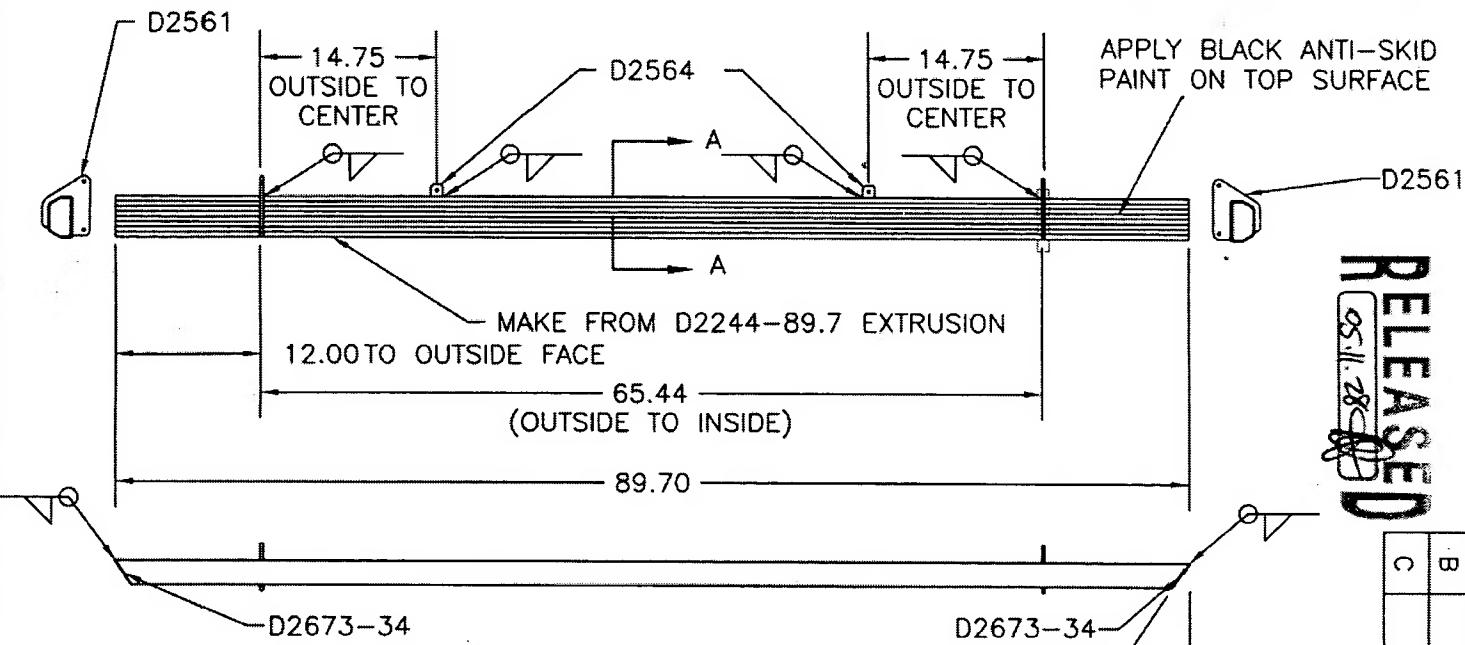
1/4/11/22 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

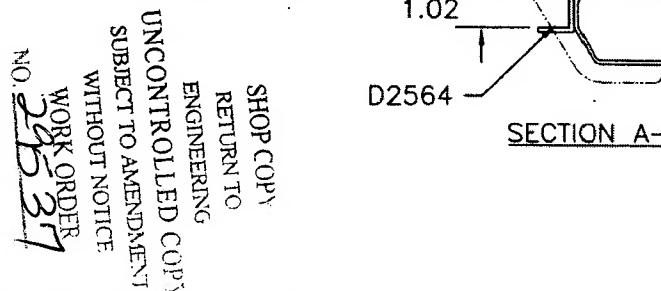
DART**D2563 STEP WELDMENT ASSEMBLY PARTS LIST**

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN BW	DRAWN BY <i>PF</i>	DART AEROSPACE LTD
CHECKED <i>MF</i>	APPROVED <i>MF</i>	HAWKESBURY, ONTARIO, CANADA
DATE 05.11.14	DRAWING NO. D2563	REV. C
	SCALE 1:15	SHEET 1 OF 1
A	96.04.26	NEW ISSUE
B	97.05.14	END CAPS CHANGED (WAS D2248)
C	05.11.14	UPDATE NOTES